

Customer	: CU-DAR001 - Dart Helicopters Services	Drawing Name	: 212/205 HIGH FED X-TUBE ASSEMBLY
Job Number	: 27987		
Estimate Number	: 10254		
P.O. Number	: <i>N/A</i>	Part Number	: D212664101
This Issue	: 7/20/2006	Drawing Number	: D212-664-141 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 7/20/2006	Drawing Revision	: B
Previous Run	: 27986	Material	: <i>N/A</i>
Written By	: <u><i>[Signature]</i></u>	Due Date	: 8/30/2006
Checked & Approved By	: <u><i>[Signature]</i> 06.07.21</u>	Qty:	1
Comment	: Est Rev: E 04.02.16 Reformat KJ/DS	Um:	Each
	: Est Rev: F 06-03-29 Remove Coments on Pick List JLM		

Job Number:



1.0 DC DOCUMENT CONTROL



Photocopy bluefile and create labels as per PPP D212-664-101CHG002

KJ 06.08.04

2.0	D6005128	Crosstube material
-----	----------	--------------------



Check OD = 2.750"; ID = 2.000"

26.02.00

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141. MS 06/09/17

MS 06/09/17

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



BR 06.09.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:04:21 PM
User: Linda, Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 27987

Part Number: D212664101

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA113

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141. *SG 06-09-17*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET *SG 06-09-19 1*

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK *J.G 06/09/19 1*

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Polish entire outside surface of crosstube *DP 6-10-2 done at Sg #13*

2-Remove sand and plugs

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141 *SG 06-09-19*

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1 *RT M-2 06/10/02*

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *Pm 06-12-80*

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE *EL/IT 7-1-17*

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06.09.14	7, 8	Please move QC & second check to after last machining of all w/o's Perm. Change	EC			<i>[Signature]</i> 07.09.14	<i>[Signature]</i> 07.09.14	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07-01-10	10.0	Roughly .020" deep marks on the inner walls of the cuff on one side only. Possibly due to tightening the sand plugs to tight, or tightening the plug as it was crooked.	<i>[Signature]</i> QS1042	Ensure sand plugs are installed correctly to not leave marks on the inner walls of the tubes. Polish out the marks using a die grinder with a flap wheel on a shaft to ensure a smooth finish. A decline polished area as per QS1005 4.1.	<i>[Signature]</i> MS 9-1-16	<i>[Signature]</i> 07-01-17	<i>[Signature]</i> QS1042	<i>[Signature]</i> 07-01-10

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:04:21 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 27987

Part Number: D212664101

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

QC6

DIMENSIONAL CHECK

QC15



Comment: DIMENSIONAL CHECK

DP 07/01/17 (1)

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

DP 07-01-17
DP/RL 07-01-19

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

DP/RL 07-01-19

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-1-19

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 2915

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

07/01/23 (1)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

07/01/24 (1)

18.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D212-664-141

07/02/01 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC. Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:04:22 PM
User: Linda, Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 27987

Part Number: D212664101

Job Number:



Seq. #: Machine Or Operation: Description :

19.0 SPRAY PAINTING : SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

ml 07 020 1

(1)

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 07 02 01

(1)

20.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

IT/2006-12-12

21.0 D2856600 Abrasion Strip



Comment: Qty.: 0.7090 f(s)/Unit Total : 0.7090 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600-851 Abrasion Strip

2660

IT 07-04-09

*

22.0 D28931 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1

Support

07475

IT 07-04-09

*

23.0 MS2192024 Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-24

Clamp

102932

IT 07-04-09

*

24.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8581

2-Install supports and clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

IT 07-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:04:22 PM
User: Linda, Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 27987

Part Number: D212664101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

DP 7-4-10

26.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

P 7/4/10

27.0	D34281	Placard
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
PLACARD
Batch: *B26249-X*

28.0	AN635A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: *M101697-X*

29.0	AN636A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: *M102929-X*

30.0	AN960JD616	Washer
------	------------	--------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)
Washer
Batch: *M103398-X*

31.0	MS21042L6	Nut
------	-----------	-----



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Nut
Batch: *M101660-X*

P 7/4/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:04:22 PM
User: Linda, Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 27987

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/04/11 *07/04/11* (1)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

07/04/11

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07/04/12 (1)

Job Completion



07.01.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27987
Description: Crosstube Assembly (205/212/412 High Fwd)	Part Number: D212-664-141
Inspection Dwg: D212-664-141 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	0.200	✓			
	R0.063	+/-0.010	0.063	✓			
	2.740	+0.005/-0.000	2.742	✓			
	5.097	+/-0.030	5.097	✓			
	2.304	+0.005/-0.000	2.307	✓			
	2.340	+0.005/-0.000	2.344	✓			
	2.398	+0.005/-0.000	2.402	✓			
	2.448	+0.005/-0.000	2.452	✓			
	2.498	+0.005/-0.000	2.502	✓			
	2.549	+0.005/-0.000	2.552	✓			
	2.599	+0.005/-0.000	2.602	✓			
	2.671	+0.005/-0.000	2.676	✓			
	2.701	+0.005/-0.000	2.706	✓			
SIDE B	0.200	+/-0.010	0.200	✓			
	R0.063	+/-0.010	0.063	✓			
	2.740	+0.005/-0.000	2.740	✓			Did not clean up
	5.097	+/-0.030	5.097	✓			
	2.304	+0.005/-0.000	2.306	✓			
	2.340	+0.005/-0.000	2.343	✓			
	2.398	+0.005/-0.000	2.401	✓			
	2.448	+0.005/-0.000	2.451	✓			
	2.498	+0.005/-0.000	2.501	✓			
	2.549	+0.005/-0.000	2.552	✓			
	2.599	+0.005/-0.000	2.601	✓			
	2.671	+0.005/-0.000	2.675	✓			
	2.701	+0.005/-0.000	2.705	✓			
	126.51	+/-0.020	126.51	✓			

Measured by: MS MS	Audited by: J.G	Prototype Approval:	N/A
Date: 06/09/17	Date: 06/09/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D212-664-141	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE XTUBE ASS'Y (205/212/412 HI FWD)	SCALE NTS
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.06.07 [Signature]

Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
2	D2856-600-851	ABRASION STRIP
4	MS21920-24	CLAMP

GENERAL NOTES:

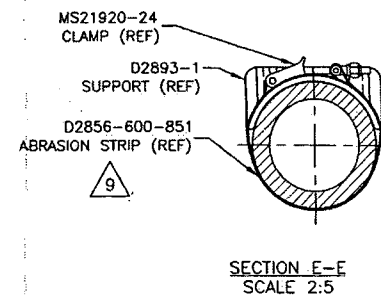
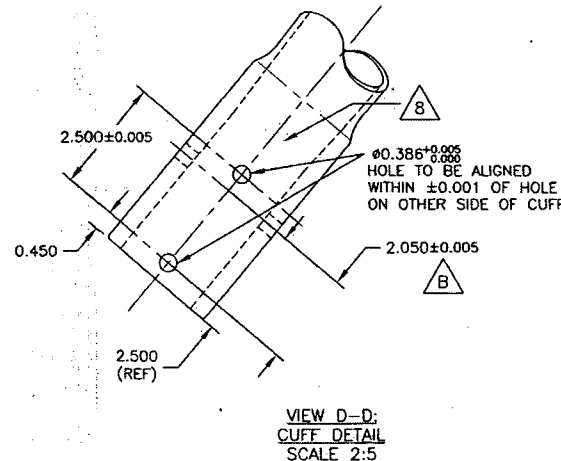
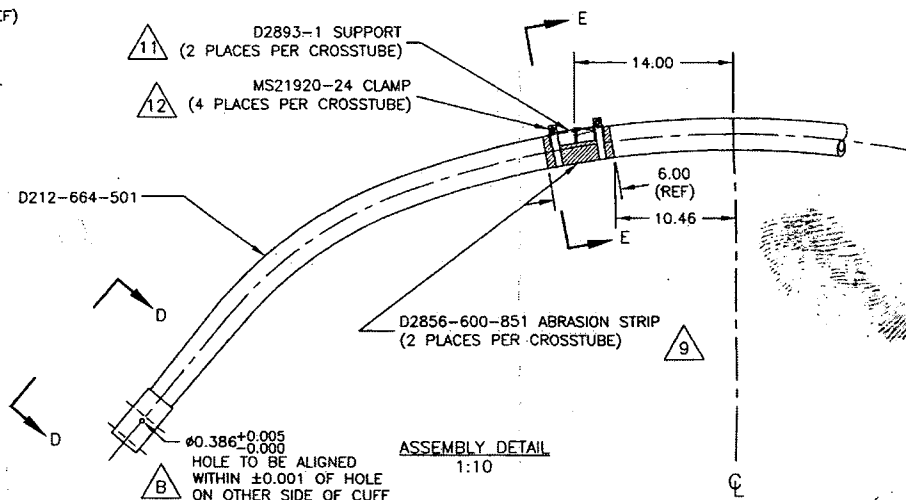
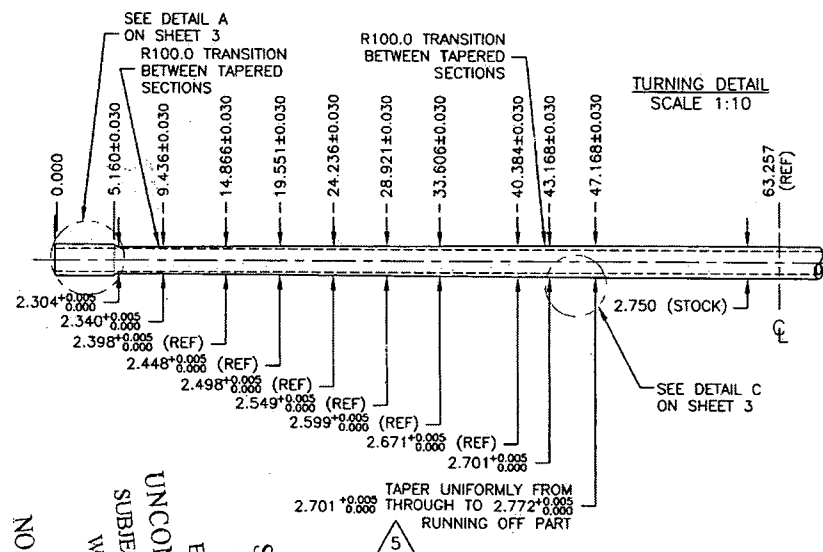
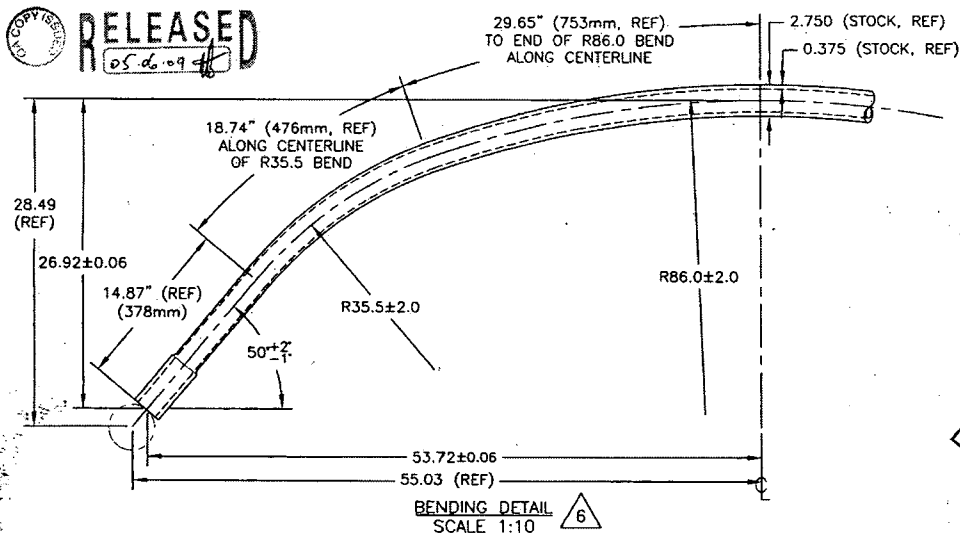
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 9) INSTALL D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2893-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27987

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05-06-09

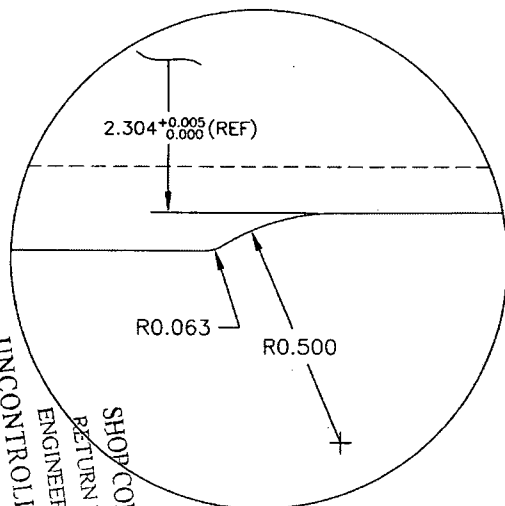
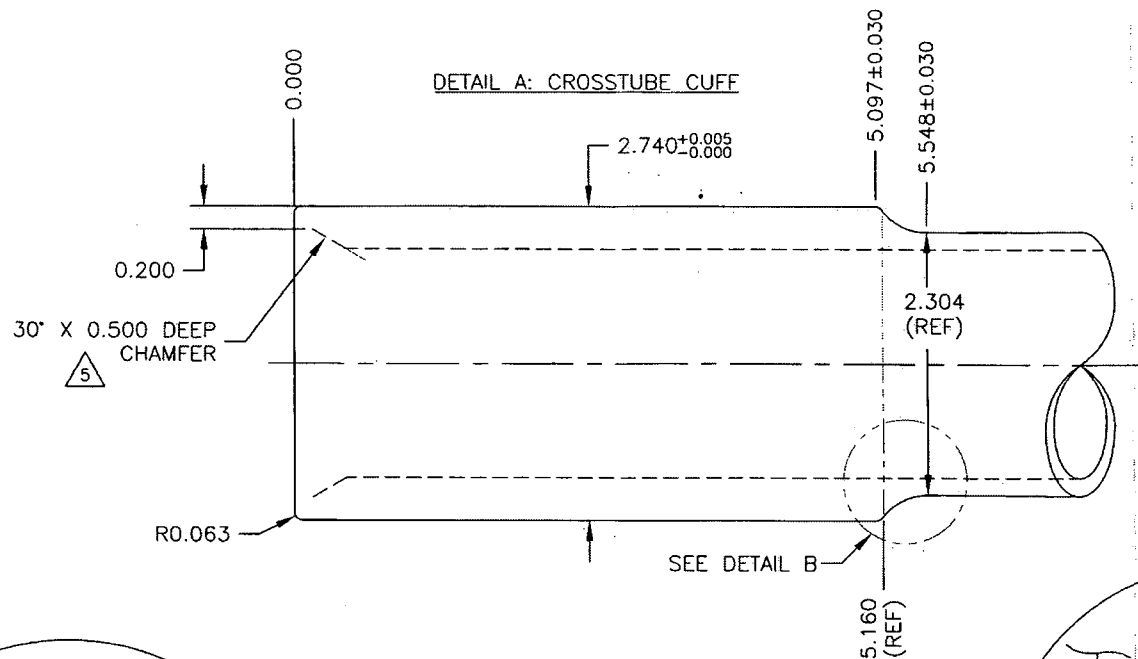


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DATE 05.02.04		TITLE XTUBE ASS'Y (205/212/412 HI FWD)		SCALE 1:10	

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WORK ORDER
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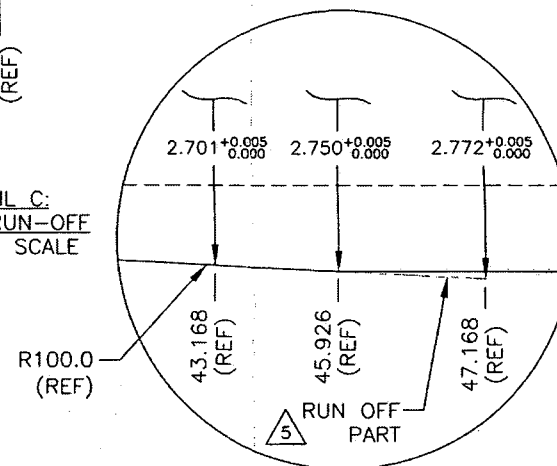


RELEASED
65 06 09 4



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



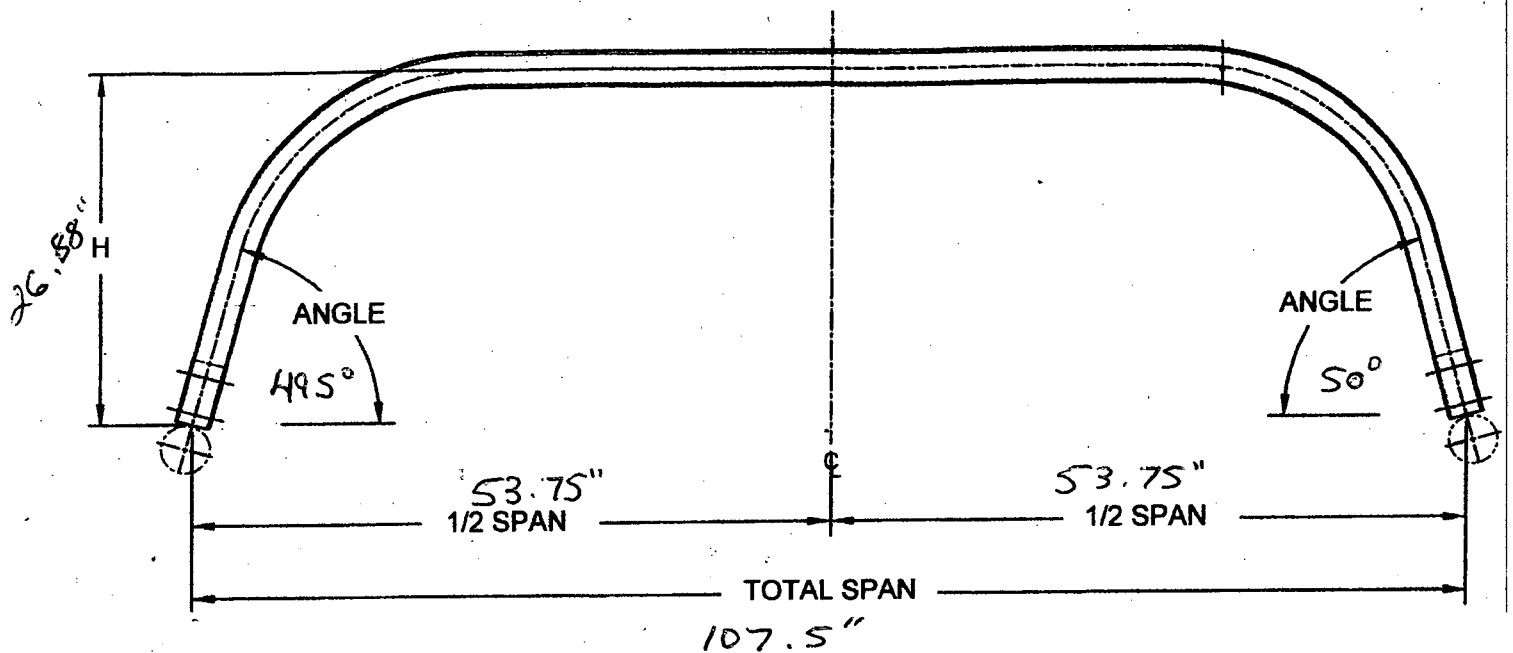
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DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. B
DATE	05.02.04	TITLE	XTUBE ASS'Y (205/212/412 HI FWD)	SCALE	1:1
				D212-664-141	SHEET 3 OF 3

NO. 27987
WORK ORDER
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Crosstube Bend Dimension Sheet



PART NUMBER: D212-664-101

BATCH NUMBER: 27987

DRAWING: D212-664-141 REVISION: B

H: 26.92

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

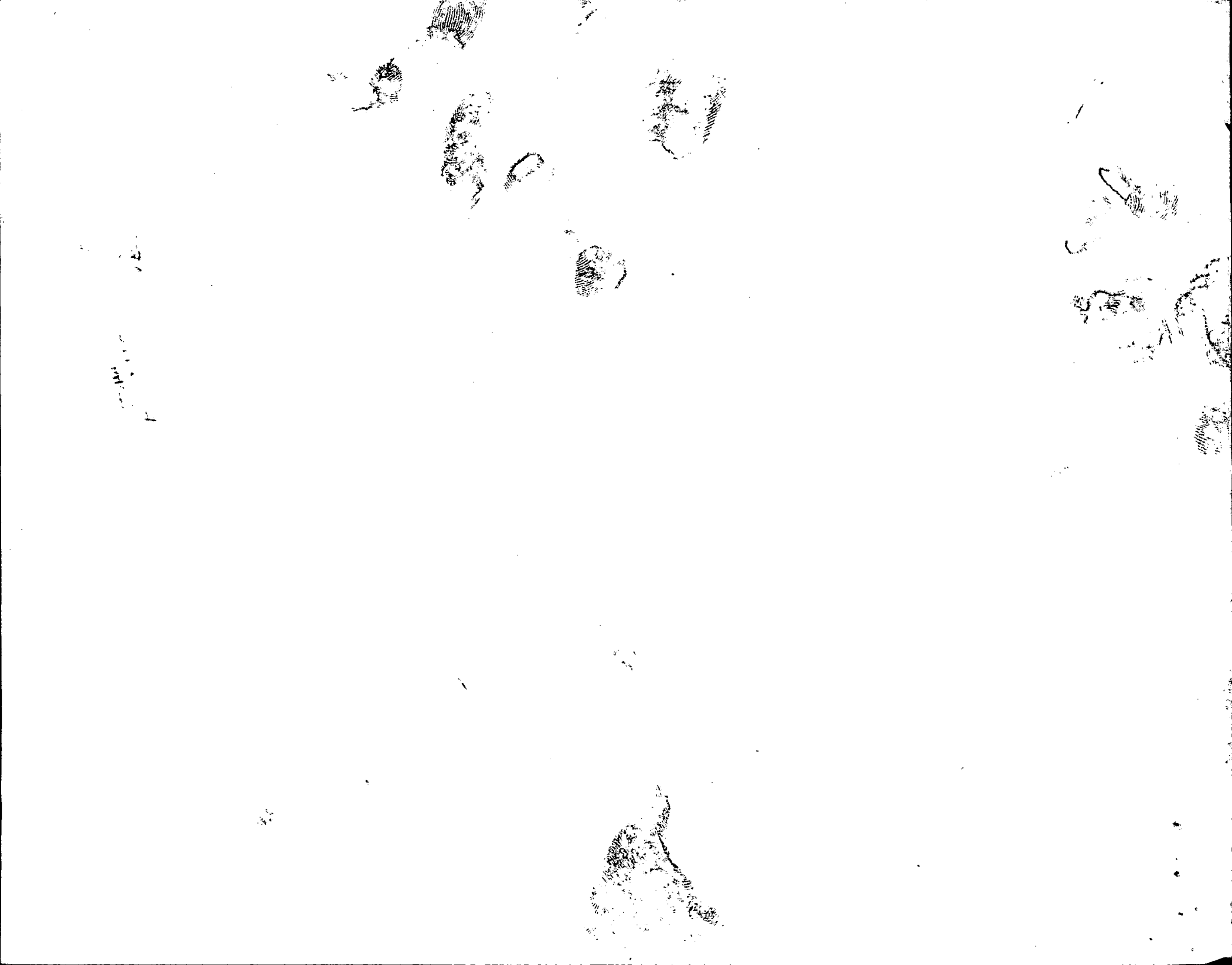
ANGLE: 50°

QC 15: [Signature]

DATE: 07-01-17

QTY: 1

[Signature]
07/01/17





HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35629

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (10) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D212-664-101 S/N B27987

Qty (3) P/N D212-664-201 S/N's B27989, B29506 & B29531

Qty (6) P/N D412-664-203 S/N's B29105, B30187, B30188, B27262, B29104 & B30190

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (10) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

Two (2) cross tubes (P/N D212-664-201) FAILED inspection. Areas marked on cross tubes (S/N's B29506 & B29531). To be reinspected following repair.
Eight (8) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: _____

DATE January 23, 2007

INSPECTION
STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

2915 ✓

ADDRESS:

CONTACT NAME:

LABOUR

@

MATERIALS

@

TRAVEL EXPENSES

@

HOTEL EXPENSES

@

\$

GST

PST

INVOICE NO.

TOTAL \$

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